

Work Order ID 86598

86598

Page 1

July-05-12 1:19:52 PM

Item ID: {D3914-041} Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: {Long Basket Lid Assembly (350)}
 Start Date: 7/05/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: CD Date: 12/07/05 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B
D4020	A

100 Weld per dwg A/R S.S. rod Batch: 122130 0.00

100
Large Fab

Large Fab

Memo

0.00

- 1- assemble ribs , weld as per dwg D3914 using DT9607A
- 2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

(1x)

12-08-03

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110
QC

Memo

0.00

Quality Control

1x

12-8-3



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86598

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Item ID: D3914-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long Basket Lid Assembly (350)

Start Date: 7/05/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 SMB 12-8-03	DAS 16 2-03	210619		1			
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo *** mask sides of hinge prior to powdercoat*** Start Time: 1h45 Oven Temperature: 320°F Finish Time: 2h15	0.00 0.00				1	2	2P	12/08/08
140 *140* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 1111250 Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***	0.00 0.00				1	x	4	11/08/08

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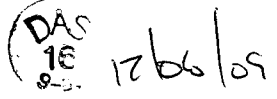
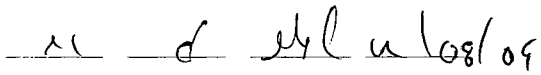
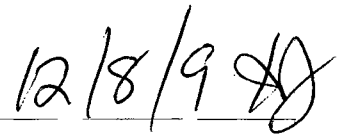
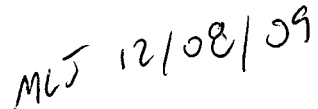
86598

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: <u>w/b</u> Memo	0.00 0.00	D4030-041/	1386599					
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-05-12 1:19:51 PM

Page 1

Work Order ID: 86598

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/05/12

Required Date: 8/10/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	61.0000	2	2			

Location	Loc Qty	Loc Code
WA	39	
82506	2	
83230	3	
85436	10	
85452	24	
WA005	22	
70766	2	
81253	1	
82897	19	

D2728-3
Dart Logo label

D3914-1
Rib

140	Each	0.0000	1	1	
100	Each	16.0000	2	2	

Location	Loc Qty	Loc Code
WA	-2	
86044	14	
WA006	18	
81449	1	
82131	1	

D3914-7
Rib

100	Each	9.0000	2	2	
-----	------	--------	---	---	--

Location	Loc Qty	Loc Code
WA	-5	
81209	1	
WA006	14	
82928	3	
86165	5	

B81209

IX

(2X) CC 12-7-31

11 12/08/09

(2X) CC 12-7-31

IX CC 12-7-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 86598

Parent Item: D3914-041

Start Date: 7/05/12

Required Date: 8/10/12

Parent Item Name: Long Basket Lid Assembly (350)

Start Qty: 1.00

Required Qty: 1.00

D4016-3
Hinge Half, Lid

Manufactured No

100 Each 19.0000

3 3

Location Loc Qty Loc Code

WA 1

84777 1

WA005 18

85776 18

(3x) CC 12-7-31

D4018-5
Rib

Manufactured No

100 Each 43.0000

9 9

Location Loc Qty Loc Code

WA 42

85728 24

86325 18

WA005 1

80776 1

(9x) CC 12-7-31

D4020-5
Mesh (350 Basket Long, Lid)

Manufactured No

100 Each 4.0000

1 1

Location Loc Qty Loc Code

WA 4

85410 4

(1)

D4021-3
Data Plate

Manufactured No

100 Each 17.0000

1 1

Location Loc Qty Loc Code

WA 17

80897 9

82507 1

85358 7

(1x) CC 12-7-31

July-05-12 1:19:52 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

July-05-12 1:19:52 PM

Page 3

Work Order ID: 86598

Parent Item: D3914-041

Start Date: 7/05/12

Required Date: 8/10/12

Parent Item Name: Long Basket Lid Assembly (350)

Start Qty: 1.00

Required Qty: 1.00

D4035-041
Lid Rib Assembly, Fwd (350 Basket)

Manufactured No

100 Each 11.0000 1 1

Location

Loc Qty

Loc Code

WA

11

63720

0

82985

2

82986

9

(IX)

CC 17-7-31

D4035-043
Lid Rib Assembly, Aft (350 Basket)

Manufactured No

100 Each 12.0000 1 1

Location

Loc Qty

Loc Code

WA

11

81452

1

82988

10

WA006

1

81202

1

(IX)

CC 12-7-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

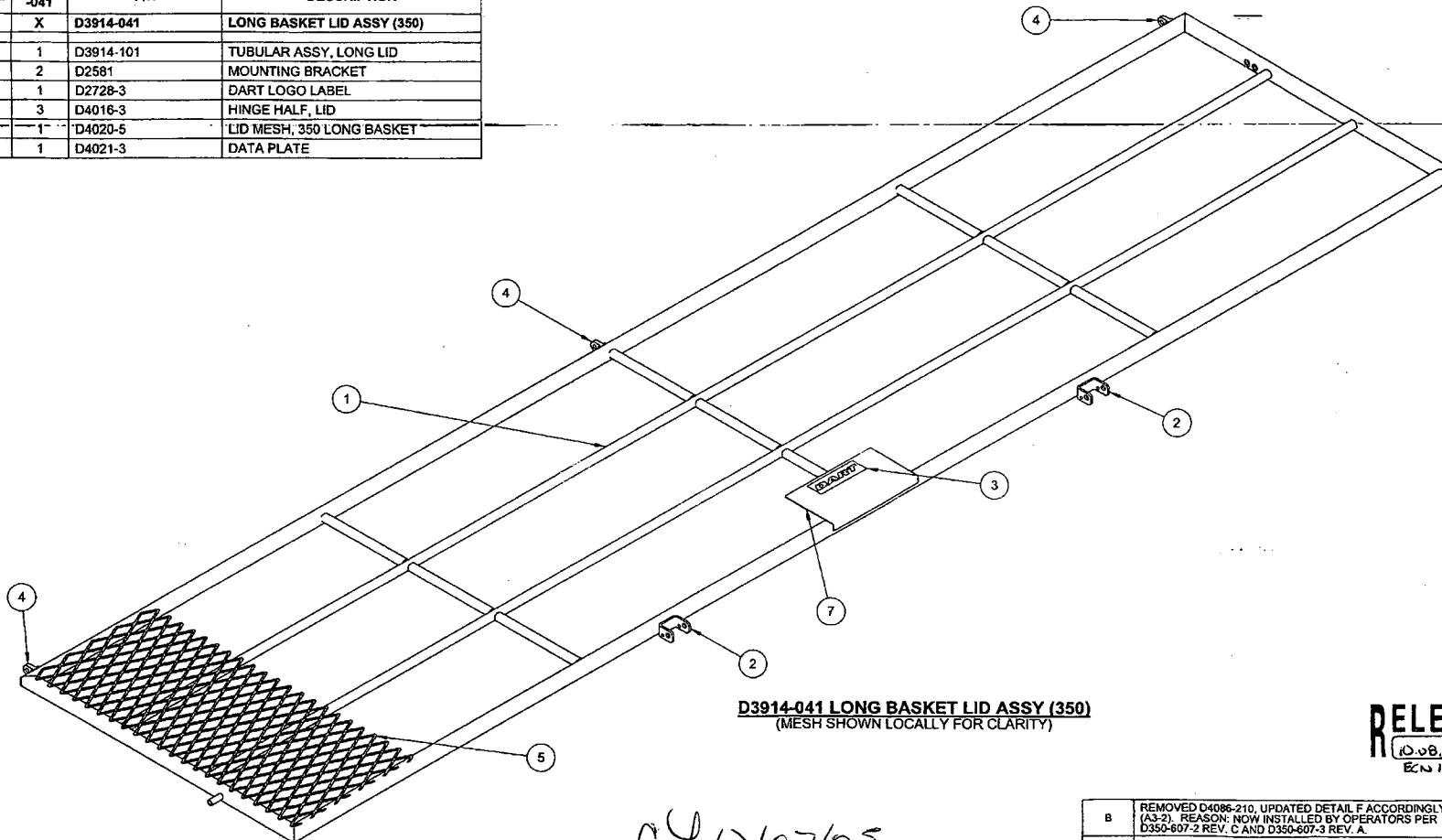
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

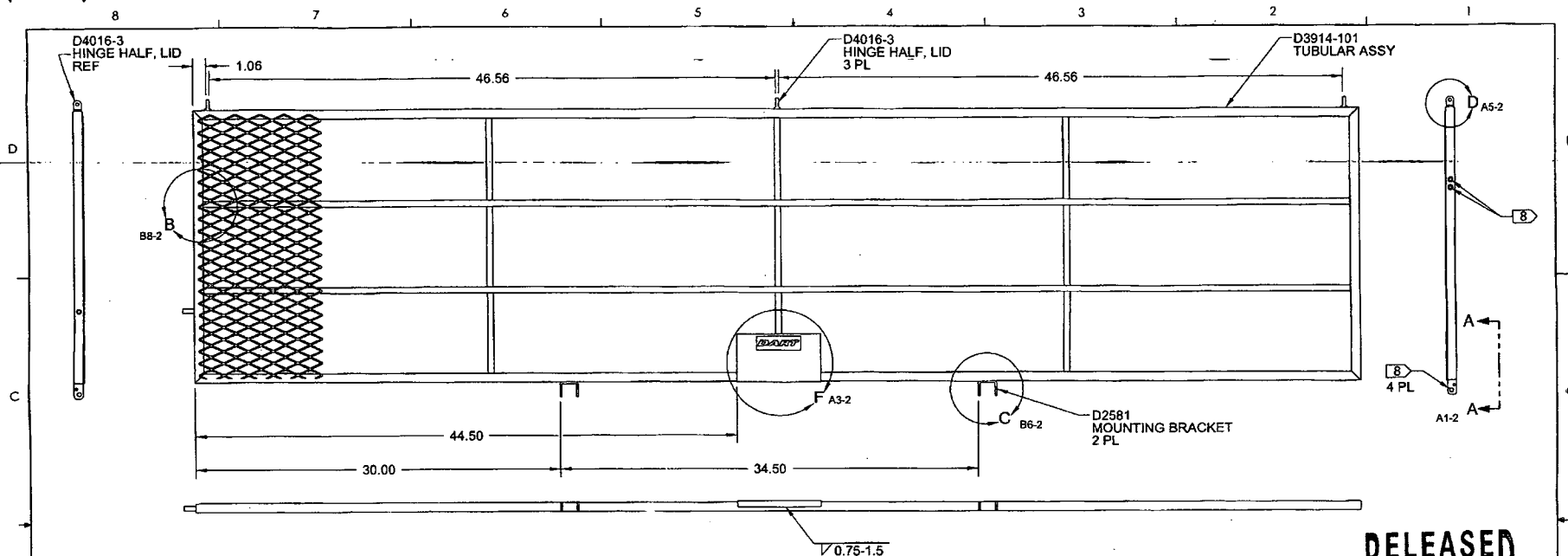


D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17
ECN 10-596

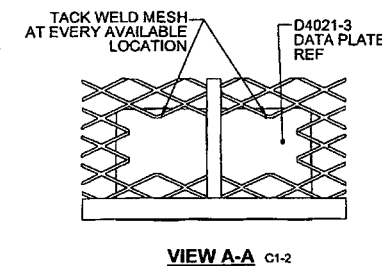
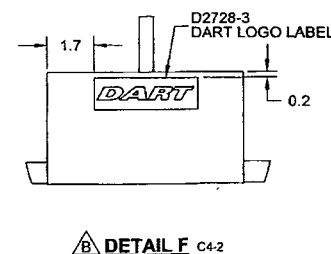
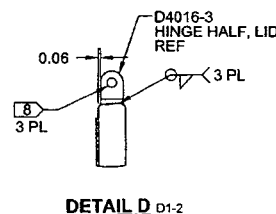
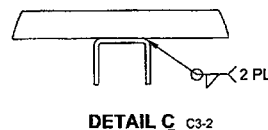
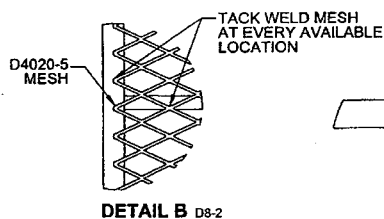
CL 12/07/05
W10: 86598

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 REV. B SHEET 1 OF 4 TITLE LONG BASKET LID ASSY (350) SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10-08-05



NOTES:

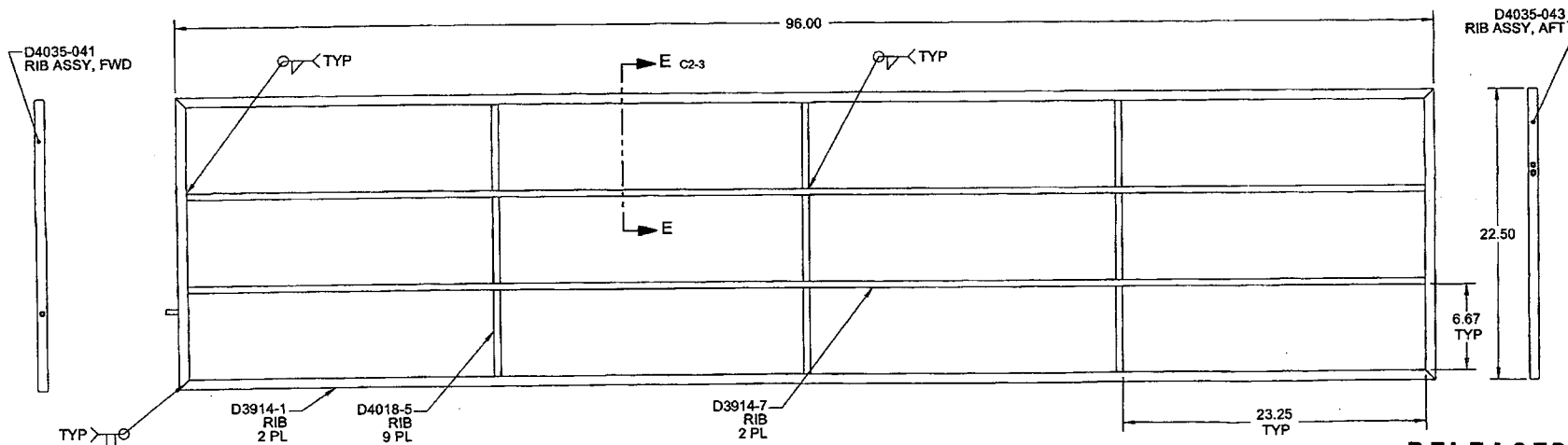
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3914	REV. B
CHECKED	SC		SHEET 2 OF 4
MFG. APPR.	WJ	TITLE LONG BASKET LID ASSY (350)	SCALE NTS
APPROVED	WJ	DATE 10.08.05	
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	RC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RC	DRAWING NO. D3914	REV. B
MFG. APPR.	WPS	SHEET 3 OF 4	
APPROVED	WPS	SCALE	
DE APPR.	WPS	TITLE LONG BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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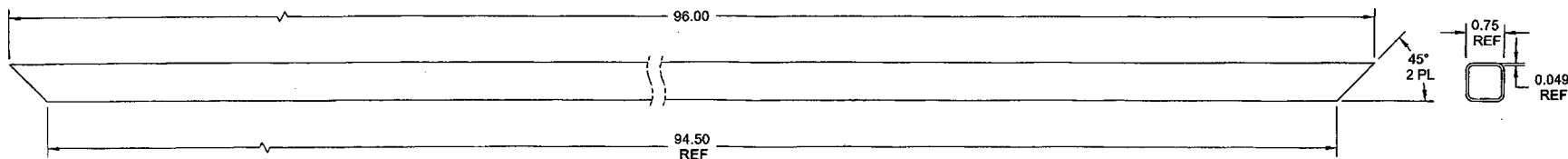
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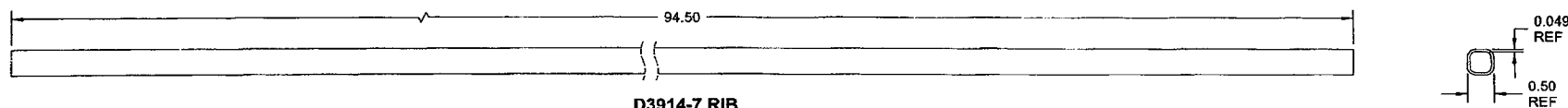
D

D

**D3914-1 RIB**

C

C

**D3914-7 RIB**

B

B

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12 CP

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3914	REV. B
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
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